

Date: Wednesday, 9/12/2007 12:13:01 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SPRING
Job Number : 34590	
Estimate Number : 10497	
P.O. Number :	Part Number : D2535
This Issue : 9/12/2007 S.O. No. :	Drawing Number : D2535 REV. A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : A
Previous Run : 31486	Material :
Written By :	Due Date : 10/10/2007
Checked & Approved By : <u>07.09.12</u>	Qty: 50 Um: 20 Each
Comment : Est. A 99.04.19 New Issue (From hand written IPP) DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 4580

Possible Supplier: Victoria Spring, 0.070 SS Torsion Spring

U 07.09.13 50

2.0	D2535P	Spring
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 SPRING

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Recieve & Inspect for Transit Damage

Ensure Material Release Note is attached

07/9/24 (50)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Check dims to dwg

02/10/02 (51) counts

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: st 36

07/10/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Day: Wednesday, 9/12/2007 12:13:02 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPRING

Job Number: 34590

Part Number: D2535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



07.10.02 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07.10.02

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

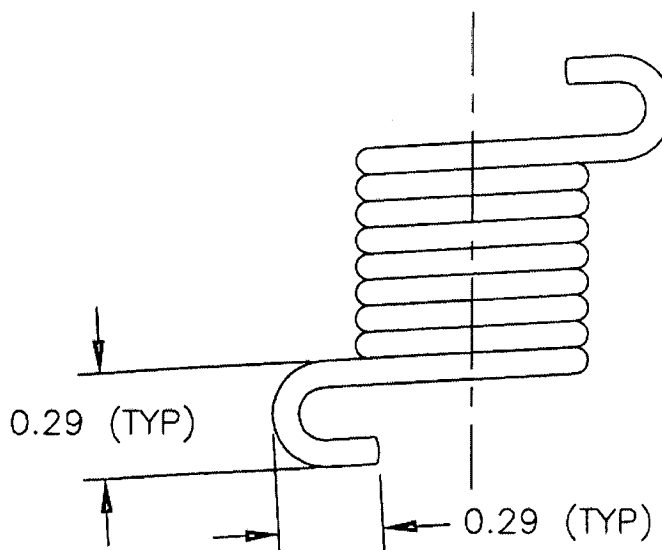
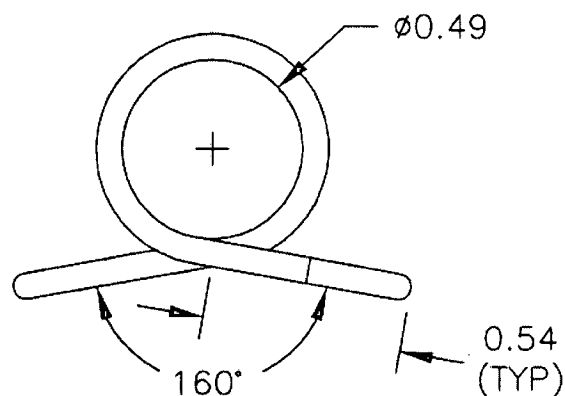
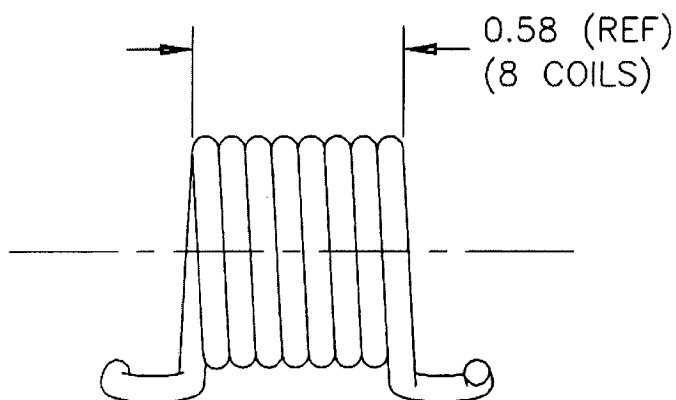
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN BW	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JH	DRAWING NO. D2535	REV. A SHEET 1 OF 1
DATE 99.04.08	TITLE SPRING SPEC CONTROL		SCALE 2:1
A	99.04.08	NEW ISSUE	

RELEASED
99.05.11 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34590

SPECIFICATION CONTROL DRAWING

TENSION SPRING WITH 8 COILS (NO GAP BETWEEN COILS)

MATERIAL: AISI STAINLESS STEEL $\phi 0.070$

POSSIBLE SUPPLIERS: VICTORIA SPRINGS, P/N .070SS TENSION SPRING

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



INVOICE 17490

#2 6104 - 82 Ave, Edmonton, AB T6B 0E7
Tel: (780) 442-4020 • Fax: (780) 468-1946

PRECISION COIL SPRINGS AND WIRE FORMS

BILL TO: Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury ON K6A 1K7

SHIP TO:

DATE		ORDER No.		SHIP VIA	
25-Sep-07		4580		Fed Ex 151793240	
QUANTITY	DESCRIPTION			UNIT	AMOUNT
50	D2535 Torsion Spring			4.50	225.00
GST #	TERMS	SUBTOTAL	FREIGHT	GST	TOTAL
854154527	NET 30 DAYS	225.00		13.50	238.50

REPORT FOR: Dart Aerospace Ltd		DATE: 9/25/2007
PO # 4580	PART/DRAWING #: D2535P	
SPRING DESCRIPTION: Torsion Spring		QUANTITY: 50

CHARACTERISTIC	SPECIFIED	MEASURED	NOTES
Material type	SS T302	Yes	
Material diameter	.070"	Yes	
I.D.	.490"	.495"	
O.D.			
Number of Coils	8 Ref.	Yes	
Free Length			
Helix	RHW	Yes	
End type	As per drawing	Yes	
Rate (lb/in)			
Finish			

COMMENTS

Mill Certificate attached: No
Material Heat Number: NA

Certified by: Jeremy Burrowes